

Date: Thursday, 9/14/2006 7:27:50 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE, INBOARD, RS, 206		
Job Number	: 28551		Part Number	: D26662		
Estimate Number	: 10821		Drawing Number	: D2666 REV. C		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 9/14/2006		Drawing Revision	: C		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 9/30/2006		
Previous Run	: 27111		Qty:	12	Um:	Each
Written By	: <i>[Signature]</i>					
Checked & Approved By	: <i>[Signature]</i>					
Comment	: Est: C 00:11:01 Removed P/O for Powder Coat - in house processEC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101001	7075-T7351 2X6X6.25
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 2X6X6.25 Issue material from stock: Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length Batch No: <i>625344</i>		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Program batch number. 1-Inspect part number and batch number are programmed correctly. 3-Fixturing Inspection last completed on <i>06/09/14</i> by <i>JL</i> 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet 7- Deburr <i>06/09/14 JL 06/09/22</i>		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet <i>JL 06/09/22</i>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>06/09/14 JL 06/09/22</i>		

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/10/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 7:27:50 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, RS, 206

Job Number: 28551

Part Number: D26662

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

~~2006-06-09-23~~

12

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Y

06/10/05 x 12

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06/10/10

12

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

06/10/11 (12)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *st 471*

06/10/11 (12)

12

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

06/10/11

12

Job Completion



06/10/11

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	28551
Description: 206 Saddle, Inboard, Right side				Part Number:	D2666-2
Inspection Dwg: D2666 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.123	.123	.123	.123		
B	0.100	0.140		.122	.122	.121	.122		
C	2.470	2.510		2.495	2.495	2.495	2.495		
D	0.100	0.180		.145	.145	.145	.145		
E	0.210	0.230		.222	.221	.221	.222		
F	1.313	1.343		1.328	1.327	1.327	1.327		
G	0.240	0.260		.254	.253	.253	.254		
H	0.615	0.685		.660	.660	.660	.660		
I	1.125	1.145		1.135	1.135	1.135	1.135		
J	0.990	1.010		1.001	1.001	1.001	1.002		
K	0.235	0.240		.237	.237	.237	.238		
L	0.510	0.515		.514	.514	.514	.514		
M	0.100	0.120		.117	.117	.115	.118		
N	1.565	1.585	DT8686B					DT8688	
O	5.990	6.010		6.000	6.003	6.002	6.003		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.491	.501	.501	.500		
S	0.313	0.318	DT8686						
T	2.495	2.505		2.499	2.500	2.500	2.499		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.313	0.318	DT8686						
W	0.540	0.560		.550	.551	.551	.551		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262	DT8683						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L	Audited by:	RG
Date:	06/09/16	Date:	06.09.23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD		Work Order:	28551
Description: 206 Saddle, Inboard, Right side		Part Number:	D2666-2
Inspection Dwg: D2666 Rev. C			Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.122	.123	.122	.121		
B	0.100	0.140		.123	.124	.122	.123		
C	2.470	2.510		2.495	2.495	2.495	2.495		
D	0.100	0.180		.145	.145	.145	.145		
E	0.210	0.230		.221	.222	.221	.222		
F	1.313	1.343		1.328	1.328	1.325	1.325		
G	0.240	0.260		.253	.253	.250	.250		
H	0.615	0.685		.660	.660	.660	.660		
I	1.125	1.145		1.136	1.135	1.134	1.134		
J	0.990	1.010		1.000	1.001	1.001	1.001		
K	0.235	0.240		.238	.238	.237	.236		
L	0.510	0.515		.514	.514	.514	.514		
M	0.100	0.120		.116	.118	.117	.116		
N	1.565	1.585	DT8888						
O	5.990	6.010		6.001	6.001	6.001	6.001		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.498	.497	.498	.496		
S	0.313	0.318	DT8686						
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.361	1.362	1.362	1.362		
V	0.313	0.318	DT8686						
W	0.540	0.560		.550	.551	.548	.548		
X	1.674	1.684		1.679	1.678	1.679	1.679		
Y	0.257	0.262	DT8683						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SL	/ SD	Audited by:	RG
Date:	06/09/17	06.09.19	Date:	06.09.23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD				Work Order:	28551
Description: 206 Saddle, Inboard, Right side				Part Number:	D2666-2
Inspection Dwg: D2666 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

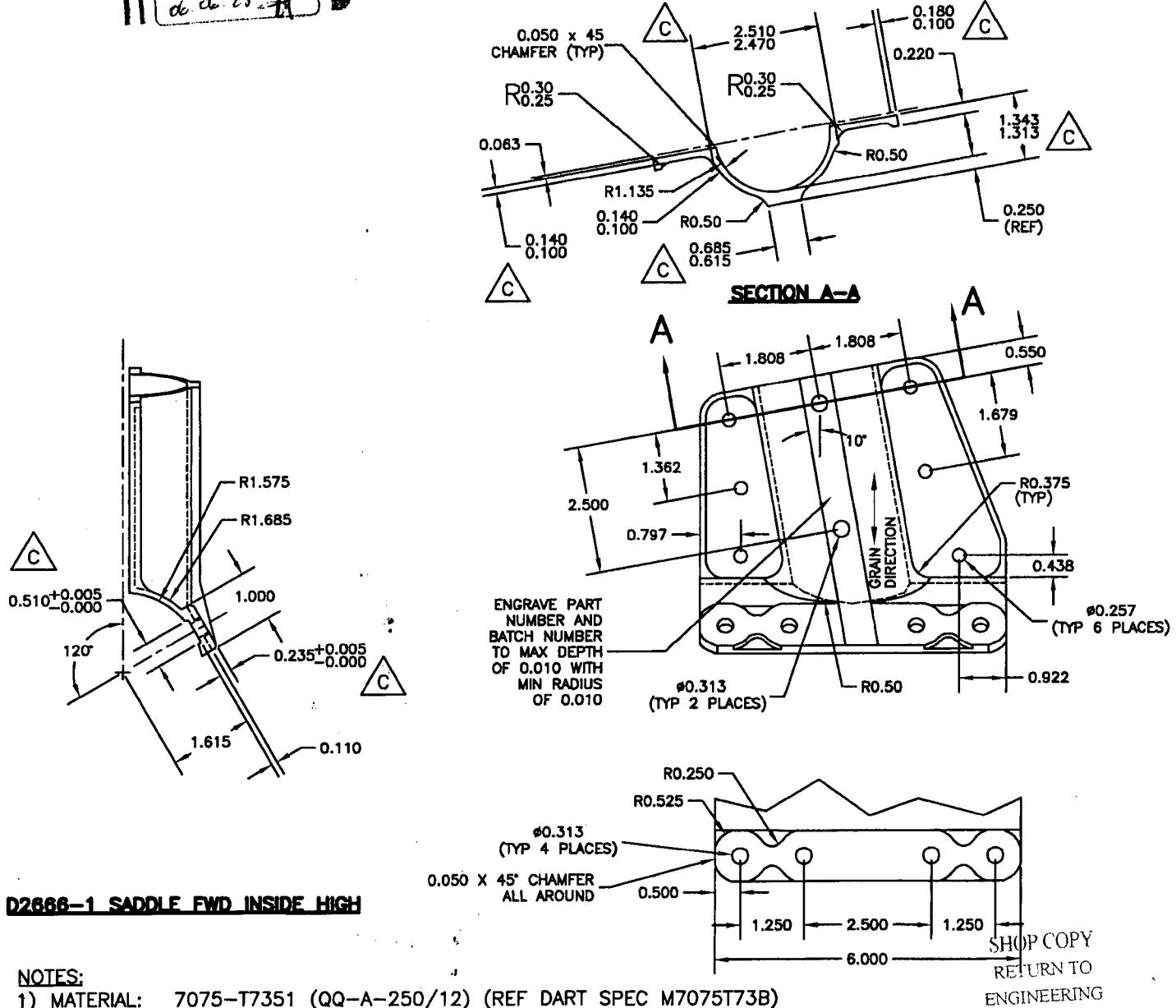
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.121	.122	.121	.122		
B	0.100	0.140		.124	.122	.123	.124		
C	2.470	2.510		2.493	2.493	2.493	2.493		
D	0.100	0.180		.145	.145	.145	.145		
E	0.210	0.230		.222	.223	.224	.222		
F	1.313	1.343							
G	0.240	0.260		.251	.250	.251	.250		
H	0.615	0.685		.660	.660	.660	.660		
I	1.125	1.145		1.136	1.1345	1.134	1.134		
J	0.990	1.010		1.002	1.001	1.001	1.002		
K	0.235	0.240		.238	.238	.238	.238		
L	0.510	0.515		.514	.514	.514	.514		
M	0.100	0.120		.117	.117	.117	.117		
N	1.565	1.585	DT 8888						
O	5.990	6.010		6.001	6.000	6.001	6.000		
P	1.245	1.255		1.256	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.495	.498	.496	.497		
S	0.313	0.318	DT8686						
T	2.495	2.505		2.500	2.499	2.500	2.499		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.313	0.318	DT8686						
W	0.540	0.560		.549	.549	.549	.549		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262	DT8683						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:		Audited by:	
Date:	06.09.19	Date:	06.09.23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM  	

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2666 REV. C
DATE		SHEET 1 OF 1
06.05.26		TITLE SADDLE FWD INSIDE HIGH
		SCALE 1:3
A	97.03.25	NEW ISSUE
B	97.07.11	ANGLE AND NOTES ADDED
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095

RELEASED
do do 29-11**D2666-1 SADDLE FWD INSIDE HIGH****NOTES:**

- 1) MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC M7075T73B)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3.5.1
- 3) TOLERANCES ARE PER DART QSI 018, UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE
WORK ORDER
NO. 28551

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